

Date: Wednesday, 06/08/2008 2:06:53 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: END PLATE		
Job Number	: 41032		Part Number	: D30671		
Estimate Number	: 10547		Drawing Number	: D3067 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 06/08/2008 S.O. No. :		Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 20/08/2008 Qty: 100 Um: Each		
Previous Run	: 40851					
Written By	:					
Checked & Approved By	: <u>JUL 08.8.06</u>					
Comment	: Est:03.01.21 Remove step 6 (Deburr) KJ Est Rev:B Now on Water jet 06-06-16 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S063	5052-H32 .063 Sheet	
		Comment: Qty.: 0.0656 sf(s)/Unit Total : 6.5625 sf(s) 5052-H32 .063 Sheet Material: 5052-H32 (QQ-A-250/8) M5052H32S.063) or6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)	Batch: <u>103713</u> <u>HB 8-8-11</u>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3067 Dwg Rev: <u>A</u> <u>HB 8-8-11</u> Prog Rev: <u>A</u>	 <u>HB 8-8-11</u> <u>08/08/20</u> <u>11P</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 <u>HB 8-8-11</u>
4.0	QC8	SECOND CHECK	 <u>08/08/06</u> <u>11P</u> <i>createn</i>
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Bend as per Dwg D3067	 <u>HB 08/08/24</u> <u>11P</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 41032

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



coated

So8/08/08

4111

Comment: INSPECT WORK TO NEXT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



111x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 62

8/8/08

SP

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



8/8/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41032
Description: End Plate	Part Number:	D3067-1
Inspection Dwg: D3067	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u> </u>	Prototype Approval: N/A
Date: 8-8-11	Date: 08/08/26	Date: N/A

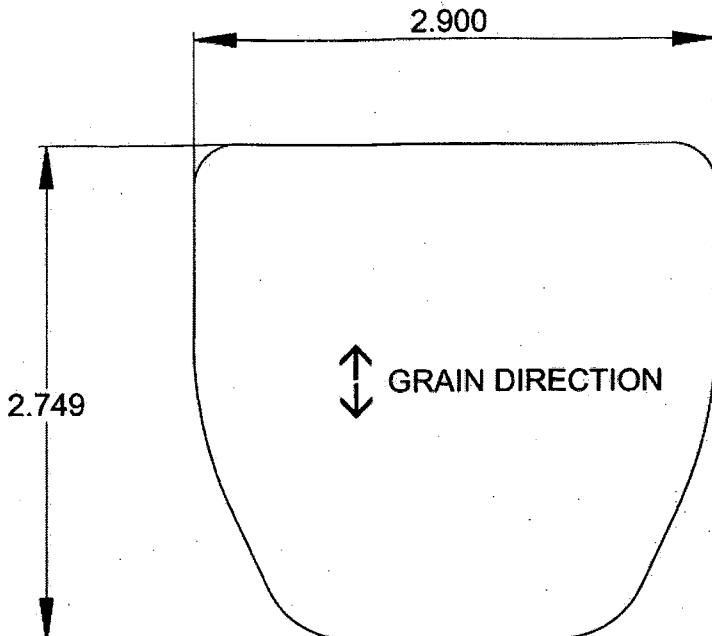
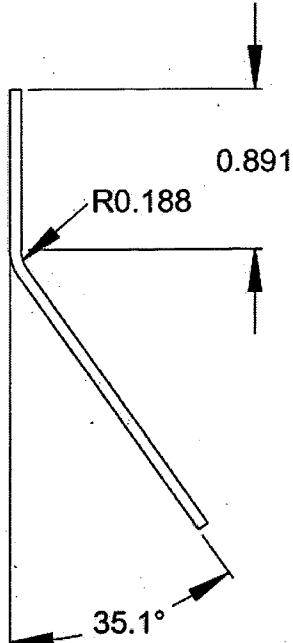
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	PF

DART

DESIGN <i>GP</i>	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>SH</i>	APPROVED <i>SH</i>	DRAWING NO. D3067	REV. A	SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1	
A	02.09.11	NEW ISSUE		

RELEASED

02.09.2011

D3067-1 FLAT PATTERND3067-1 BEND DETAIL**D3067-1 END PLATE**

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063) CONTROLLED COPY
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41032

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